

Work Order ID 66342

Thursday, February 10, 2011 11:26:01 AM



ASAP

Page 1

Item ID: D2958

Accept



Setup Start



Revision ID:

Stop



Item Name: Window

Start Date: 2/10/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/11/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *mf* Date: *11-02-10*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2958

Rev E

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

B11-2-10

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-2-10

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Swartz



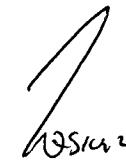

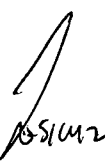
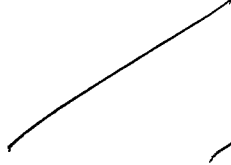
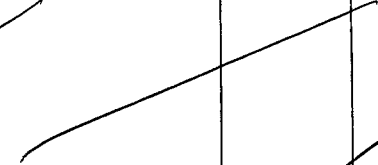
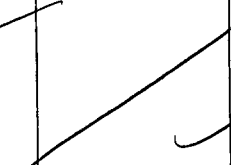
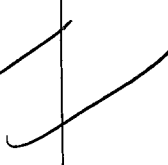

(X3)

x2

Pho

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2958 PAR #: _____ Fault Category: S-Fab-W-Jet NCR: Yes No DQA: 11/02/10
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 11/02/14

NCR: <u>66342</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/02/10	#100	Found in each window the a chip / mark caused by water Jet. one window has a large small chip on the side and		Scrap & replace. M <u>113201</u> Qty x2		S 11/02/11		
		The other window has a large large chip (blowout in it). R.C. Process						



NOTE: Date & initial all entries




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Thursday, February 10, 2011 11:26:01 AM

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Item ID: D2958	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Window					
Start Date: 2/10/2011	Start Qty: 2.00		Cust Item ID:		
Required Date: 2/11/2011	Req'd Qty: 2.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Thermoform Thermoforming Machine	THERMOFORMING MACHINE Memo Thermoform as per Dwg D2958 and Folio FTA005□Dwg. Rev. <u>E</u> □ Folio Rev. <u>B</u>	0.00 0.00				x3			<u>DL</u> 11/02/14
140  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Check product for scratches mal-formation or any other non conformances.	0.00 0.00				x3			<u>DL</u> 11/02/14
150  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(x3)			<u>Sulozky</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 66342

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Item ID: D2958

Accept

Setup Start

Revision ID:

Stop

Item Name: Window

Start Date: 2/10/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 2/11/2011 Req'd Qty: 2.00

Customer:




Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Water sand and buff to remove scratches as required <input type="checkbox"/> Wrap in protective film	0.00 0.00				x3			DL 2/10/11
170  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(x3)			
180  Packaging Packaging	Identify as per dwg & Stock Location: <u>St</u> Memo	0.00 0.00				(x2)			

used one window (D2958) X1
w/o 66376
Stores = (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D2958

Accept



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Stop



Item Name: Window

Start Date: 2/10/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/11/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/14 J

WIP
11-02-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Thursday, February 10, 2011 11:25:56 AM

Page 1

Work Order ID: 66342

Parent Item: D2958

Parent Item Name: Window



Start Date: 2/10/2011

Required Date: 2/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP E: 01.09.25 ☐ Done by outside contract ☐ SM
 IPP F: 07.06.26 Thermoform in house DL
 IPP G: 07.09.28 Rev E dwg EC verified by: DD
 IPP H: 08.11.24 Step 8 revised per w/o 41134 KJ Verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125 		Purchased	No			100	sf	150.4222	2.58	5.431579			
1/8" Polycast II Sheet													

B11-2-10

Location

Loc Qty

Loc Code

MAT

150.4222

113204

4

114673

1.1722

115338

145.25

113204

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

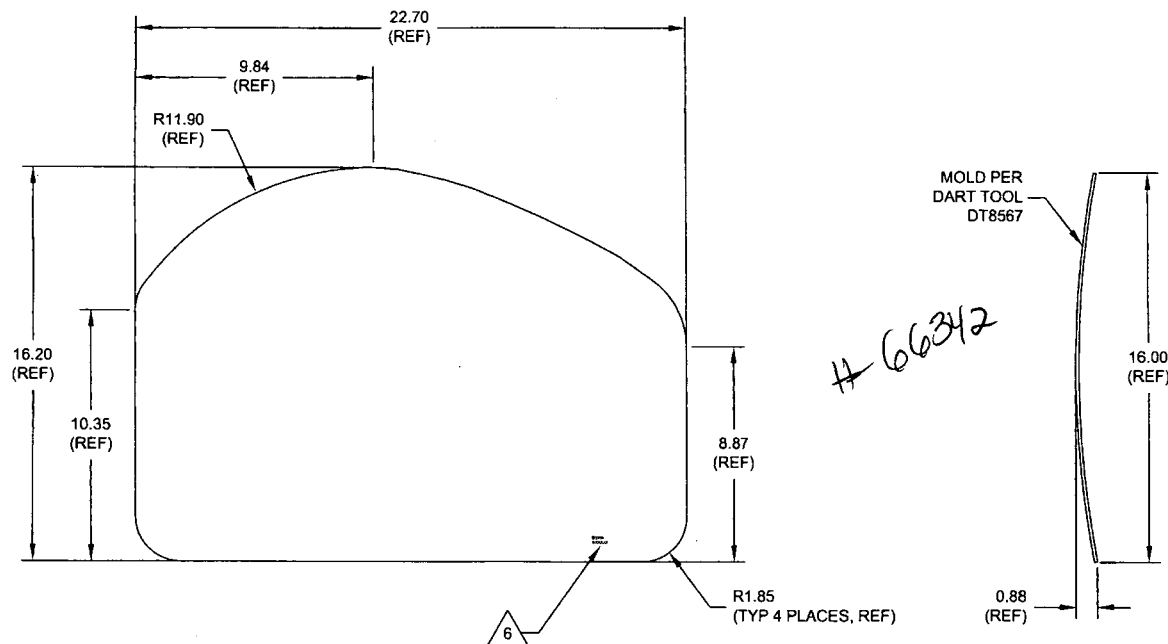
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C.Closed: _____ Date: _____

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NOTE: Date & initial all entries



D2958 FLAT PATTERN

D2958 WINDOW:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D2958" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.58 +/- 0.35 LBS
- 8) MOLD PER DART TOOL DT8567

RELEASED
07.09.22

E	UPDATE DIMS PER PAR 188	DC	07.07.06
D	UPDATE MATERIAL PER NCR 029	SSH	06.04.13
C	REMOVE HOLES, UNIFORMLY SMALLER	CP	01.05.30
B	Ø0.156 HOLES WERE Ø0.141 (NCR 407)	CP	00.02.23
A	NEW ISSUE	CP	00.01.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.06		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. E
D2958 SHEET 1 OF 1
TITLE SCALE
WINDOW 1:5

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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